

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027272**Date Inspected:** 05-Mar-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs. Ca

CWI Name:	Chris Concha		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** SAS Travelers**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the Westmont Industries (WMI) job site in Santa Fe Springs, California between the times noted above in order to monitor fabrication and the Quality Control functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path). The following items were observed:

Traveler Brake Modification Assembly's (CCO232) Blast and Paint.

This QA Inspector was informed by RPI Coating's Mr. Preston Keen that RPI will be blasting the Traveler Brake Modification Links. This QA Inspector randomly observed RPI personnel preparing for blasting operations on the 2A/2B, 3A/3B traveler brake modification link assemblies. The parts were observed after blasting for uniformity and complete area coverage. Upon completion of the blasting, Mr. Keen performed three (3) random surface profile tests utilizing extra course (XC) film strips. This QA Inspector observed an average reading of 3.06 mils. (Acceptable range; 1.5mils-3.4mils) Mr. Keen was observed performing a soluble salts test and this QA Inspector observed a reading of 0. Environmental readings were obtained and recorded prior to and upon completion of coating. The following batch numbers are for the zinc coating applied.

Part A-XM1611FB

Part B-XM2341JX

Part F-0761

E2/E3-East Bound Traveler

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector randomly observed WMI welder Cesar Canales (ID 3195) perform Flux Core Arc Welding (FCAW) plug welds for four (4) holes on 1 ½ x 1 ½ tube steel on the scaffolding of the traveler. The welder was observed installing the 5/8 x 1 9/16" ASTM A572 gr. 50 plugs and performed the welding in the 3G vertical position. The welder completed the work by employing a small disc grinder to grind the excess to a smooth flush surface condition. This QA Inspector noted that the work was completed on this date and ABF-RFI-002701R00 was referenced prior to and during the procedure.

Navigation Light Mounts

This QA Inspector randomly observed WMI welder Daniel Grayum (ID3049) tack weld the 1" x 12" threaded studs to 150mm x 170mm x 6mm plates on the navigation light mounts for the SAS Travelers. QC Inspector Christopher Concha was observed performing the fit-up operations and monitoring the welding. The welder was observed performing the FCAW process to tack the studs in place and weld the complete penetration joint (CJP). This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress.

This QA noted above items observed appear to comply with the contract documents.

Summary of Conversations:

As noted above.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer